

Work Order ID 153622

153622

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Wednesday, November 30, 2016 1:18:03 PM

Item ID: PB67-43001-143

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Square Tube

Start Date: 11/22/2016 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: UMF Date: 11-22-2016 Tooling: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	d

100 0.00

100

Small Fab

Large Fab

Memo

0.00

Large Fab

1- Cut to length as per dwg

2- Make a chamfer on one end only as per dwg

3- Drill holes as per dwg

4- Deburr

1 FF NOV 30 2016

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

0.00

Quality Control

① 11-12-01 DAS
9
9-89

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Item ID: PB67-43001-143 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Square Tube
Start Date: 11/22/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/2/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>me222</u>	0.00							
140									
Packaging	Memo	0.00							<u>ME 16-12-02</u>
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							<u>DAS 21 9-89</u>
Quality Control									<u>DEC 05 2016</u>

ME
16-12-02

Picklist Print

Tuesday, November 22, 2016 3:15:37 PM

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Work Order ID: 153622

153622

Parent Item: PB67-43001-143

PB67-43001-143

Parent Item Name: Square Tube

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
16.11.22 DWG REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 5		Purchased	No			100	f	19.5591	1.458	3.069474			

M6061T6TS1 000W 125

6061T6 SQ TUBE 1.00 x 1.00 x .125w

FF

NOV 24 2016

Location

Loc Qty

Loc Code

MAT028

19.559111

m128034

19.559111

3.069474

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

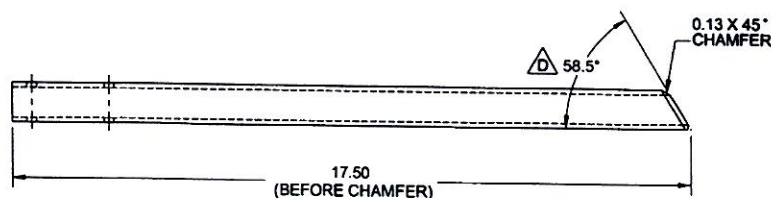
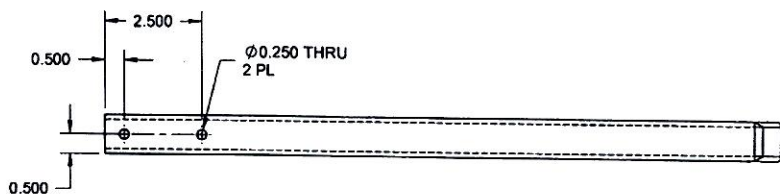
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D

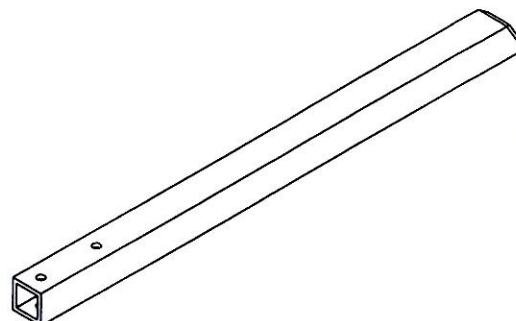
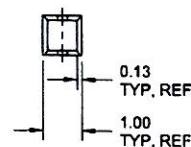
C

B

A



B67-43001-143 SQUARE TUBE



2 153620
+ MF 16-11-22

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.73 lbs

RELEASED
2016-11-09
EN 11-655

APPROVED

D	ADDED ANGLE DIM. (ZN B5-1) REASON PAR15-437	SAD	16.08.25
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 22 OF PREMIER AVIATION DRAWING No. B67-43001. REASON SEE PAR#09-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-143	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	16.08.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1